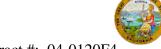
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-009663 Address: 333 Burma Road **Date Inspected:** 10-Oct-2009

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. Chen ying xin No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay -11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 058009 perform SMAW welding on, Spare strut splice plate, Weld joint no. WD1-SA3-18-99M-8-1A. ZPMC CWI Identified as Mrs. Yu dong ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Trial assembly area

- 2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049220 perform FCAW welding on, Doubler plate in Skin A to façade plate, East tower, lift 1. ZPMC CWI Identified as Mr. Wang xiao bing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4132.
- 3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202323 perform SMAW welding on, Doubler plate in Skin A to façade plate, East tower, lift 1. ZPMC CWI Identified as Mr. Wang xiao bing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4114.

WELDING INSPECTION REPORT

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Machining area

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066479 perform SMAW surface repair welding on, AB corner, inside East tower, lift 3, weld joint identified as ESTL3-4B/K-82A. ZPMC CWI Identified as Mr. Li hong fei . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)- repair.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as East tower, Lift 3, AE corner and CD corner diagonal plate, the weld designation reviewed is as follows:

ESTL3-4B/K-81A –East, Lift 3 – AE corner inside ESTL3-4B/K-81B –East, Lift 3 – AE corner outside –Ring area ESTL3-4B/K-77, 78 –East, Lift 3 – CD corner inside – Diagonal plate

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer